



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

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D4079-1

Job Sheet 182627



Part No: D4079-1

Job Qty: 4 ea

Part Name: Clamp Half, Attachment



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/29/18

Job Tracking No:

Due Date: 9/14/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP REV: A NEW ISSUE 10*-05-10 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	9/14/18	9/14/18	0.00	0.00	Start Up Machining-2		SBL 18/10/01
100	Bandsaw	4 pcs	9/14/18	9/14/18	0.00	0.28	Bandsaw1		SBL 18/10/01
110	CNC Vertical Machining	4 pcs	9/14/18	9/14/18	0.22	2.84	HAAS1-4		SBL 18/10/01
130	QC	4 pcs	9/14/18	9/14/18	0.00	0.00	QC8 Machining-2		SBL 18/10/01
140	HandFinish	4 pcs	9/14/18	9/14/18	0.00	0.13	HandFinish1		D.R. 18/10/18
150	Powdercoat	4 pcs	9/14/18	9/14/18	0.00	0.07	Powdercoat4		BR 18-10-18
160	QC	4 pcs	9/14/18	9/14/18	0.00	0.00	QC3		OCT 0 7 2018
170	Packaging	4 pcs	9/14/18	9/14/18	0.00	0.00	Packaging3-2		OCT 0 3 2018
180	QC21-SA	4 Ea	9/14/18	9/14/18	0.00	0.00	QC21		OCT 0 2 2018

Part Op 100 - Cut blank 2.750" long

Descriptions: 110 - Mill as per Dwg and Folio FA931 Dwg Rev:

M138839 START: 11:45 00.1330 FINISH: 12:15

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B2.000X02.000	6061-T6 Bar 2.00 X 2.00	2.00 ea (23 ea) 2,76	90-Start up Operation	5114822

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B2.000X02.000	1	10	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Clamp Half, Attachment	2.502Inches $\pm$ 0.010	2.512 2.492		2,501
2	Clamp Half, Attachment	0.203Inches + 0.005 - 0.001	0.208 0.202	Diameter	0.203
3	Clamp Half, Attachment	0.750Inches $\pm$ 0.030	0.780 0.720		782, 746
4	Clamp Half, Attachment	0.375Inches $\pm$ 0.010	0.385 0.365		371
5	Clamp Half, Attachment	0.310Inches $\pm$ 0.010	0.320 0.300		308

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____ Descripti _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS Water Jet ☐ Engineering ☐ od. Eng. Coord. ☐ Quality ☐ ore/Packaging ☐ Other ☐ Supplier ☐ MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval DART Aerospace Ltd. 1270 Aberdeen Street Hewesbury, ON K6A 1K7 CANADA TEL.: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com Part: D4079-1 Job No: 182627 Serial No/Batch: S114823 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 10/01/18
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Root Cause	Pressure/Forced	Temperature/Cure	Power Loss/Surge	Positioned Wrong
Environment ☐	☐	☐	☐	☐
Design ☐	☐	☐	☐	☐
Doc/Data ☐	☐	☐	☐	☐
Equip/Tooling ☐	☐	☐	☐	☐
Handling/Pre ☐	☐	☐	☐	☐
Material ☐	☐	☐	☐	☐
Internal Transport ☐	☐	☐	☐	☐
Tribal Knowledge ☐	☐	☐	☐	☐
LOA ☐	☐	☐	☐	☐
Substation ☐	☐	☐	☐	☐
Past Expiry Date ☐	☐	☐	☐	☐
Misidentified ☐	☐	☐	☐	☐
No Re-verification ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Operator ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Offset/Setup ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Supplier ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Training ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Use for Testing ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Poor Information ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
Rushing ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Product Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Process Improvement ☐	OTHER : _____			
Manufacturing Process ☐				
Past Due ☐				

6	Clamp Half, Attachment	1.882Inches ± 0.010	1.892 1.872		1, 881
7	Clamp Half, Attachment	0.780Inches ± 0.030	0.810 0.750		, 782
8	Clamp Half, Attachment	0.130Inches ± 0.030	0.160 0.100	Radius	, 130
9	Clamp Half, Attachment	1.440Inches ± 0.010	1.450 1.430		1, 436
10	Clamp Half, Attachment	0.380Inches + 0.010 - 0.000	0.390 0.380	Radius	, 380
11	Clamp Half, Attachment	0.050Inches ± 0.010	0.060 0.040	Radius	, 050
12	Clamp Half, Attachment	0.730Inches ± 0.010	0.740 0.720	Radius	, 730
13	Clamp Half, Attachment	0.257Inches ± 0.030	0.287 0.227	Diameter	, 257
14	Clamp Half, Attachment	0.250Inches + 0.006 - 0.001	0.256 0.249	Radius	, 250
15	Clamp Half, Attachment	0.390Inches ± 0.030	0.420 0.360		, 391
16	Clamp Half, Attachment	0.850Inches ± 0.010	0.860 0.840		, 853
17	Clamp Half, Attachment	0.025Inches ± 0.010	0.035 0.015		, 025
18	Clamp Half, Attachment	45.000Degrees ± 0.500	45.500 44.500	Angle	45
19	Clamp Half, Attachment	0.100Inches ± 0.010	0.110 0.090		0, 098
20	Clamp Half, Attachment	0.050Inches ± 0.030	0.080 0.020	Radius	, 050
21	Clamp Half, Attachment	1.240Inches ± 0.010	1.250 1.230		1, 240
22	Clamp Half, Attachment	1.650Inches ± 0.030	1.680 1.620		1, 651
23	Clamp Half, Attachment	0.600Inches ± 0.030	0.630 0.570		, 600
24	Clamp Half, Attachment	0.230Inches ± 0.030	0.260 0.200		, 229
25	Clamp Half, Attachment	0.025Inches ± 0.010	0.035 0.015		, 024

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				